Work Order ID 86935 July-09-12 2:51:26 PM						*869	35*							Page 1
Revision ID:	D212-664-2 Crosstube Lo	207 ow Standard Af	t			Accept	*N900	040	100	* s	etup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	7/06/12 7/06/12	Start Qty: Req'd Qty			*1* *1*		Cust Item Customer:							
Approvals:		an: MLT		Date: \Z	, ,	O Tooling: SPC (Y/N):		Date:		R	un	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	•	Operation Description				Set Up/ Run Hours	Tool ID	Tool#	Pian Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr					V* <.							
D212-664-247	Re	v B (DEO)					DAS					^		
*100 *100* DC Document Control			Memo	efile and cre	ate labels :	0.00 0.00 as per PPP D212-664-207	15 15 15 15 15 15 15 15 15 15 15 15 15 1				4	0(N	165/	2-10-31
*110 *11 \n* Packaging Packaging		Pick Kit Packaging	Мето .			0.00			Mo	12	/10	17	-	-
120 *120* CNC Bend 2			IACHINE - C Memo	ROSSTUBE	:S	0.00		: 	ΝÓ	/- Ru	,	12-	10-1	8
CNC Alpha 160 Ben	der		Bend tube as p FT	per Dwg D21	2-664-24	7 using CNC bender progra	am and Folio	,	/					•

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Dart Ae	rospace	e Ltd							
W/O:			WC	ORK ORDER CHANGE	S				•
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	10 DQ	A:	_ Date: _	
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DATE	STEP	Description of NC	on of NC Corrective Action		ı B	- Verification		Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Revision ID:	D212-664-2			*N90004010					Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date: Reference:	7/06/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Iter Custome					-	^N;	S7°
Approvals:	Process P	lan:	Date:	Tooling:		Date:]	Run	Start Stop	*N	R1*
* - -	QC:		Date:	SPC (Y/N):		Date:				Stop	*N	R2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC15- Crosstube Dimen	isional Check	Set Up/ Run Hours 0.00 AS 0.00 SAS	Tool II	Tool#	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
140 *140* Crosstubes Crosstubes		2-Drill pilot	holes in tube as per Dy	0.00 0.00 2-664-247 using DT8972.** wg D212-664-247 using DT8	•			14	Ŋ		2-10	-20
		4-*** WEA & Inspect fo 664-247	R LATEX GLOVES Wor surface damage. Rep	as per Dwg D212-664-247 /HEN HANDLING CROSST pair damage within limits as pair damage within limits as pair damage within limits as par Dwg D	oer Dwg D212-	Tu)		IZ-	. 10 ¬	2Z	-2-

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Part No	art No: PAF		Fault Categ	ory:	NCR: Yes	No DQA	:	Date: _							
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Work Order ID 86935 July-09-12 2:51:26 PM			*869	335*							Page 3)	
Item ID: Revision ID: Item Name:	D212-66 Crosstube	4-207 Low Standard Aft		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	1 3	S1* S2*	
Start Date: Required Date:	7/06/12 : 7/06/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:							
Reference: Approvals:	Process QC:	Plan:	Date:			ate:			Run	Start Stop	17	R1* R2*	
Sequence ID/ Work Center II 150 *150* QC Quality Control	D	Operation Description QC5- Inspect part comp Memo *** WEAR	•	Set Up/ Run Hours 0.00 16 0.00 2-5	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
160 **160* HandFXtube Hand Finishing Cro	osstubes			0.00 0.00 EN HANDLING CROSSTU	JBE***							0AS) 05	d 10 (
180 *180* Outsource2		Outsource process - ND	CROSSTUBE WITH W T per QS1038 4.1	0.00 0.00					- H		12-10-	13	

Liquid Penetrant Inspection as per QSI 038
Issue P/O://1233_LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

Outsource process - NDT

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES				•						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	·	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No	:	PAR #:	Fault Cated	aory:	NCR: Y	es N	o DQ	 A:	Date:						
		esolution:													
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DATE	STEP	Description of NC		Corrective Action Secti			Verific	cation	Approval	Approval					
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Work Order ID 86935

86935

Page 4

- July-09-12 2:51:26 PM

D212-664-207 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Crosstube Low Standard Aft **Start Date:** 7/06/12 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/06/12 Req'd Qty: 1.00 Customer: Reference: Run Process Plan: Date: Tooling: Date: Approvais: Stop SPC (Y/N): Date:_____ Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Receive & Inspect for Damage & Mat'l Certs 0.00 190 Packaging *100* 0.00 Packaging Memo Packaging *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order. QC5- Inspect part completeness to step on W/O 0.00 200 0.00 Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **Ouality Control** Inspect for damage & ensure results are as per Dwg D212-664-207

Insp.

204

Crosstubes Chemical Conversion

0.00

HandFXtube

Hand Finishing Crosstubes

Memo

0.00

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1- PRESSURE WASH AND THEN USE WASH'N WIPE TO CLEAN CROSSTUBE AND CUFF BEFORE CHEMICAL CONVERSION

Ry 12-10-24

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W/O:			WO	RK ORDER CHANGE	S				• •
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	10 DQ	A:	Date: _	
Resolution:			Disposition	l: <u>'</u>	QA: N/C Clo	sed:		Date: _	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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	Work Order ID 86935 uly-09-12 2:51:26 PM			OD:	935*						Page 5
Item ID: D2 Revision ID:	212-664-207	7		Accept	*N900	040	100)* s	etup Si		NS1*
Item Name: Cro	osstube Low	Standard Aft							S	top *	NS2*
Start Date: 7/0 Required Date: 7/0		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:) :					
Reference:			•						•		
Approvals: Pi			Date:	Tooling:	Da	Date:		R		tart *	NR1*
Q			Date:	SPC (Y/N):	Da	te:			S	top *	*NR2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	t Rejec Numb	
206		QC7-Inspect Chemical C	onversion Coat	0.00	~A0						_
206		Memo		0.00	DAS Mistole						
Quality Control		*** WEAR I	LATEX GLOVES WHE	N HANDLING CROSSTU	UBE***						

1 0 0 AB
12-10-25

210

210 Crosstubes

Crosstubes

Memo

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Crosstubes

1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247, with Sika flex in Between tube & Cuff

0.00

A/R SIKAFLEX -241/-291 BATCH: 123025

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W/O:			WC	RK ORDER CHANG	ES				• •						
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Part No	Part No: PAR #: _		_ Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _							
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NCR:		W	ORK ORDI	ER NON-CONFORMA	NCE (NCF	3)									
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign 8		cation		Approval						
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Work Orde		6935		*869	35*							Page	6 .
tem ID:	D212-664-	207		Accept	*N900	040	100)*	Setup S	tart	*N:	S1*	
tem Name:	Crosstube L	ow Standard Aft							S	top	*N:	S2*	
Start Date:	7/06/12	Start Qty: 1.00	*1*		Cust Item I	D:							
Required Date: Reference:	7/06/12	Req'd Qty: 1.00	*1*		Customer:								
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:				tart	*N	R1*	
	QC:		Date:	_ SPC (Y/N):	Da	ate:			S	Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Oty	Reject Qty		Reject Number	Insp. Stamp	
215 * 915 * QC Quality Control		QC5- Inspect part compl Memo *** WEAR	eteness to step on W/O LATEX GLOVES WHEN	0.00 0.00 J.6 I HANDLING CROSSTU	1/10/26 BE***					 .	<u>_</u>		
		Inspect of	cuff with T-Pin										
220 *220*		Spray Painting per QSI0 SprayPaint	05 4.2	0.00				١				0AS 05 5	12 10 S
SprayPaint		Memo		0.00								05	_184 10 8
Spray Painting		*** WEAR	LATEX GLOVES WHEN	I HANDLING CROSSTU	BE***								
		1-Prime insi	de and outside crosstube	as per QSI 005 4.2									
		2-Paint outs	ide crosstube with White	Imron as per QSI 005 4.2									
		PRIME: Start Time: Fininsh Tim											

PAINT: Start Time: 2160 Finish Time: 3160

Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANG	ES					
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NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				· · · · · · · · · · · · · · · · · · ·
		Description of NC		Corrective Action Sect	ion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Secti		Chief Eng	QC Inspector
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Work Ordo July-09-12 2:51		935			*869	35*							Page	7
Item ID: Revision ID:	D212-664-20)7			Accept	*N900	040	100)*	Setup	Start	*N:	S1*	 .
Item Name:	Crosstube Lov	v Standard Aft									Stop	*N:	S2*	•
Start Date: Required Date:	7/06/12 7/06/12	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Item I Customer:	D:							
Reference:									j	Run	Start	* N I I	D 4*	
Approvals:	Process Pla	nn:	Date:		_ Tooling:	Da	ite:				Stop	171	K1 "	
	QC:	·	Date:	-	_ SPC (Y/N):	Da	ıte:				Stop	*NI	R2*	
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
230		QC14- Inspect Spray Paint	t		0.00									
23U		Memo			0.00				T		12	-(0	-29	(1)
Quality Control		Wrap in plasti	c bag to pro	etect from sc	ratches									
240					0.00	•							. Ω Δ0	
240		Crosstubes							Ì				05	12.10.24
Crosstubes		Memo			0.00								8-89	
Grosstubes		1- Assemble a	is per Dwg I	D212-664-24	1 7									
		1-Abrade mat clean the area			and crosstube with 400 gri	t sandpaper,								

2-Install supports with Proseal 890 per DSI9563 and QSI 015 A/R Proseal 890 Batch: 123103

3- Torque bolts as per dwg

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W/O:			W	ORK ORDER CHANG	GES				-	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQ	A:	Date:	
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Revision ID:	D212-664			Accept	*N900	040	100)* s	etup Sta Sto	i VI	S1*
		Low Standard Aft							510	, *N	S2*
Start Date: Required Date: Reference:	7/06/12 7/06/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:					
Approvals:		Plan:				ate:		R	tun Sta Sto	17	R1*
	QC:		Date:	_ SPC (Y/N):	В	ate:				*N	Rツ*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*250 *250*		QC5- Inspect part compl	eteness to step on W/O	0.00 (SA S)	11/0/30						
QC Quality Control		Мето		0.00							
255		Pick Kit		0.00				,		JB	12/10/308
255 Packaging Packaging		Memo		0.00				/	1-12	11/30	12/10/30/
260		QC4- 100% Inspect kits	for completeness	0.00	046 15						
260 QC Quality Control		Memo		0.00 D)						

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W/O:			WO	RK ORDER CHANG	GES				
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Work Ord		935		*869	3.5*	•					Page 9
Item ID: Revision ID:	D212-664-20	07		Accept	*N9	900	040	100)* s	etup Start	*NS1*
Item Name:	Crosstube Lov	w Standard Aft								Stop	*NS2*
Start Date:	7/06/12	Start Qty: 1.00	*1*			st Item I	D:				14()/
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Approvals:		ın:	Date:	Tooling: SPC (Y/N):			ate:		F	tun Start Stop	"NR1"
Sequence ID/ Work Center I 270		Operation Description Packaging	Date.	Set Up/ Run Hours	T	ool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Packaging Packaging		Memo Identify an	d pack for shipping as pe		3						2 1/2/3 \$P
²⁸⁰ *280*		QC21- Final Inspection	- Work Order Release	0.00						12	110/3104
QC		Memo		0.00							

Quality Control

N121031

Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANG	ES			· .	3′
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July-09-12 2:51:25 PM

Work Order ID:

86935

Parent Item:

D212-664-207

Parent Item Name:

Crosstube Low Standard Aft

Start Date: 7/06/12

Required Date: 7/06/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A New Issue 07.09.12 EC verified by: JLM IPP Rev:B ECN 1100p 08-01-11 DD verified by: EC IPP Rev:C ECN 1121 08-02-25 DD verified by:eC

IPP Rev: D GC5 replaced by QC15 at step 5 KJ Verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-207TRNRevA Crosstube Turning Detail		Manufactured	No	B89	855	110	Each	0.0000	1		N	20	12/10/
D3660-1		Manufactured	No			140	Each	16.0000	2	2			,
CUFF				803 ST482 535	01	Loc Oty 4 4 12	<u>Lo</u>	c Code		2	M	0 12	10/18
CR3212-4-06 CHERRY RIVET		Purchased	No	769 1 3 1	83 237 8	220	Each	372.0000	44	44	AR	12-10	1-25
				Location ST330 120 122 ST331 112 113	9521 9141 9492 9717	Loc Oty 319 119 200 53 18 8 27	<u>Lo</u>	oc Code					

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NCR:		V	WORK OR	DER NON-CONFORMA	NCE (NCR)).			1 - 100 - TABLE 1
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID:	86935					C/ 4.T	7/06/12		D
Parent Item:	D212-664-207						Date: 7/06/12		Required Date: 7/06/12
Parent Item Name:	Crosstube Low Standard Aft					Start	Qty: 1.00		Required Qty: 1.00
D3595-063-530 RUBBER CUSHION	Manufactured	No		240	Each	137.0000	4	4	W 12.10.29
		L	ocation	Loc Oty		Loc Code			
		L	G	98					
			79932	18					
			82656	80					
	1	N	1 АТ052	39					
	pt 87833		63407	6					
	15 0.032		67185	6					
			70067	18					
			72745	2					A .
			75783	7					
D2940-1 Support	Manufactured	No		240	Each	31.0000	2	2	W12.10.29
•		1	ocation	Loc Qty		Loc Code			
	17	L	.G052	31					
	B#71829		79118	11					ı
			82657	20					1
MS21920-28 Clamp(per MIL-DTL-87	Purchased (83C)	No		240	Each	88.0000	4	4	W12.10.29
		<u>I</u>	ocation	Loc Qty		Loc Code			
		F	rG	5					
			105884	5					
		L	.G050	25					
	`		116839	2					
	5# 123243		118713	4					
	B# 123243		120054	2					
			121067	17					
		I	.G051	58					
			121440	8					
			122204	50					

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DATE	STEP	Description of NC		n B	VATIT		Approval	Approval	
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ork Order ID:	86935										
rent Item:	D212-664-207							Sta	rt Date: 7/06/12	Required Date: 7/	/06/12
rent Item Name:	Crosstube Low Stan	ndard Aft						Sta	art Qty: 1.00	Required Qty: 1.	.00
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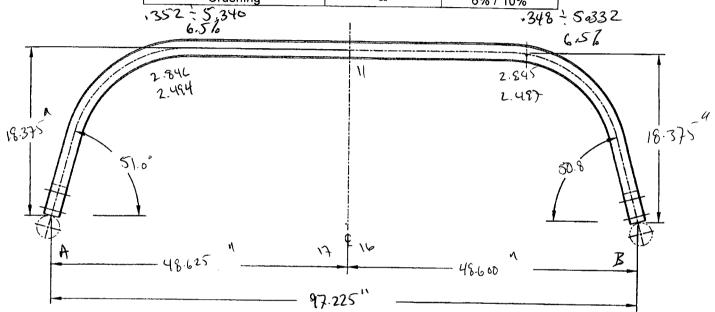
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DART AEROSPACE LTD	Work Order:	86935
Description: Crosstube Low Aft (205/212)	Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62
Bending Passes	8	
Crushing		6% / 10%
352-5,340		-348



		Side A	\	MiDDLe	Side B
Bending Pass	es	17		11	16
Crushing		6.5%			6.5%
		Comn	nents		
Sine A2	6.5%	chushin	0	17 PA	121
Mipple = (61 81	3->5-5			
Sme Bz (6.57.	Crushing		0 161	Passes
				<u> </u>	200

QC15 Inspection	DAO.
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Date	10 171.010
Date	1 0 0000

Rev	Date	Change	Revised by	Approved
Α	08.02.29	New Issue	KJ/JM	Apploted
В	10.04.01	Dwg Rev updated	KJ A	
С	12.04.16	Added bending, crushing dimensions	KJ dal	10

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Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		. X	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

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В

1) MATERIAL: MANUFACTURED FROM D6008-132

FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2

TOLERANCES ARE PER DART OSI 003 4.2

TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED.
UNITS: INCHES UNLESS OTHERWISE NOTED.
BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.

7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664) D212-664-247B = 36.6 lbs (PER IIN-D212-664)

PART IS SYMMETRIC ABOUT CENTERLINE.
WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD

10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%

BASED ON O.D., EXCEPTUP TO 10% IS ALLOWED IN AREA NOTED.

12 LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

13 LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

14 LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER

INSTALLATION AND PRIOR TO PACKAGING.

13) INSTALL MS21920-28 CLAMPS (OR 30) WITH DS3595-063-530 RUBBER CUSHIONS TO SECURE THE 02940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.

14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE

SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS

NOT BOTTOMED-OUT AFTER TORQUING.

16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.

17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER MLT NO. 86935 MLT 12/07/10

DEO ATTACHED

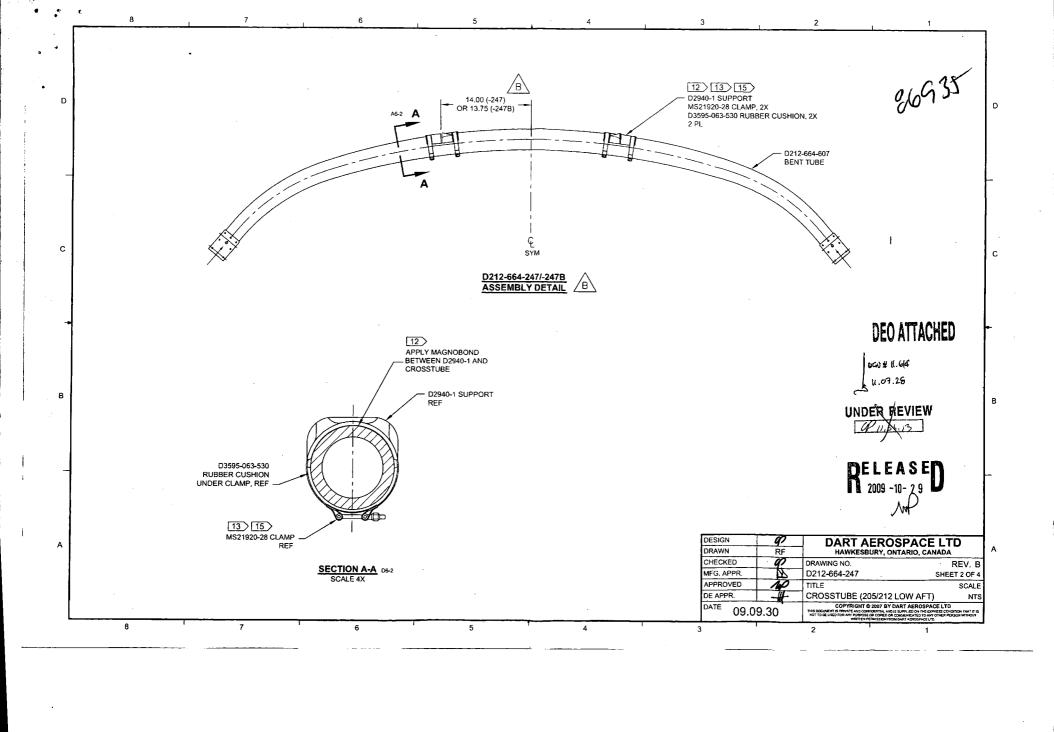
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8			OTES/PART LIST; UPDATE TO RDS; ADD -247B (ZN C4-2, D5-2)	RF	09.09.30		
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REV.			DESCRIPTION	BY	DATE		
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CHECKED 97		q?	DRAWING NO.		REV. B		
MFG. AF	PR.	- B	D212-664-247	SHEET 1 OF 4			
APPROVED 10		10	TITLE		SCALE		
DE APPR.			CROSSTUBE (205/212 LOW AFT) NTS				
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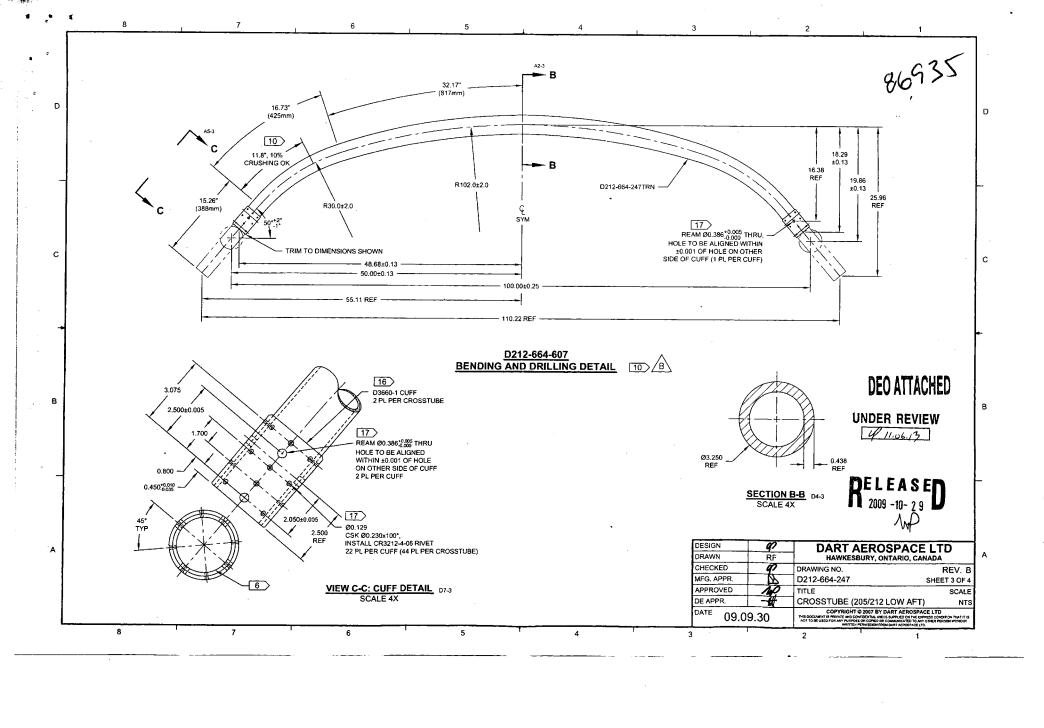
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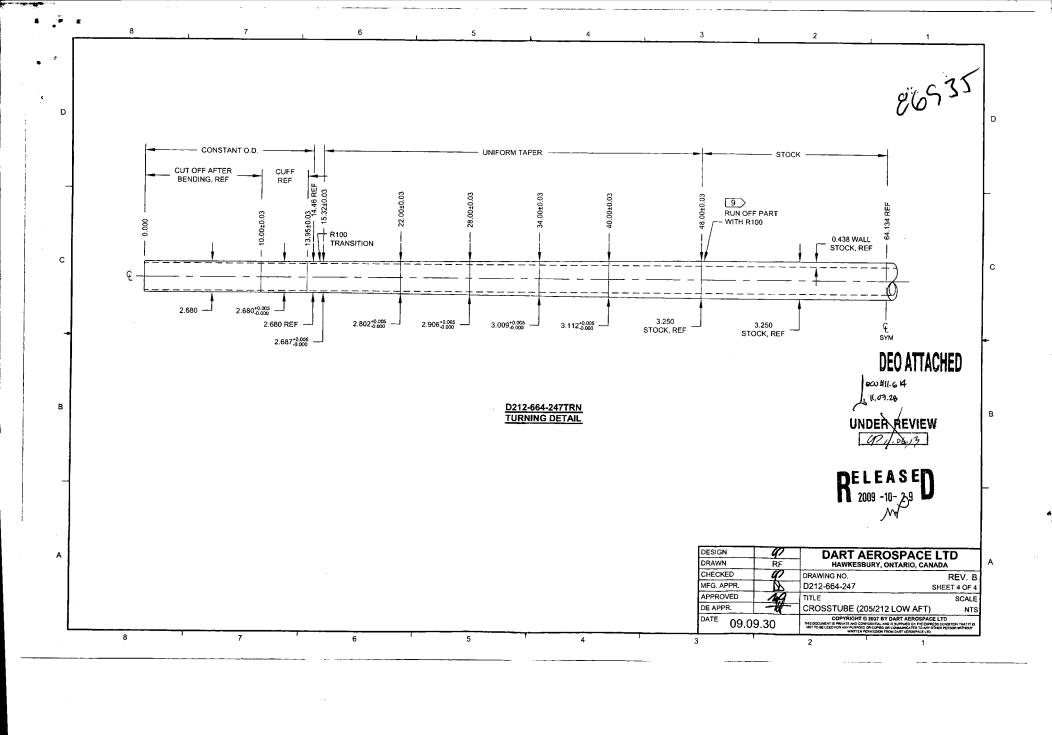
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DRAWING NO. D212-664-247	TITLE CROSSTUBE ASS'Y (205	REV. B	DART AEROSPA		SHEET NO. SC	CALE
DRAWN 9	CHECKED	A>S	MFG. APPR.	ORDER D212-664-247-B-1	DE APPR.	NTS
DATE 11.07.	15 DATE //,	27.70	DATE 11.07.2		DATE 11.07.21	

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

26935

CHANGE:

IS:

ltem	Qty -247	Qty -247B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS

- 12) TO INSTALL D2940-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

WAS:

- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.



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WRITTEN PERMISSION FROM OART AEROSPACE LTD.

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LIQUID PENETRANT TEST REPORT

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CLIENT	Dart A	erospace		DATE	Oct 23	2012 T	IME AM	PM 🗆	
ATTENTION		LINDA, ANDY		ACUREN JOB NO.	7				
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	HAWKesbu	ery on		WORK LOCATION	As ALD	hess			
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PROJECT	Pt-wet	Vorsent Lig	uid Penc	trunt inso	ection				
ITEM(S) EXAMINED	•								
(0)	<u> </u>								
JOB DESCRIPTION	ON	PROCEDURE NO. LT-	REV./DATE	2009	TECHNIQUE N O.	LT-XXXXX F	REV./DATE	1e07	
Part No.				MATERIAL Alu	minium /s	THICK	NESS		
	med 6	wet Flue L.P	I on	100% 01 -	the ort	enel &	Surlace	2	
SCOPE PER		mentionned t	_	our of					
Ori	Jierro	PRATIONIES L	<u>kuu</u>						
TEST DETAILS		DECOENT DV	ISIBLE	WATER WASH	П	SOLVENT REMOVA	ABLE 🔲	Post Emulsified	
METHOD FAMILY BRAND	Yacne flux		ISIBLE	BLACK LIGHT S/N				AMBIENT < 2 fc	
PENETRANT	16516710X	MINIMUM DWELL TIME	165 MIN.		☐ FLASHLIGHT □	TROUBLELIGHT	☐ OUTPUT>1	00 fc @ SURFACE	
PENETRANT REMOV		MINIMUM DRY TIME	>10 M IN.		1-0000	,	O D D	- 4383.40	
	5K0-62	MINIMUM DWELL TIME	3 0 Min.	LIGHT METER S/N	109 8866		CAL DUE DATE	E <i>oct }8 2012</i>	
DEVELOPER TYPE TEST SURFACE		UEOUS AQUEOUS	□ DRY	<u> </u>			<u> </u>	***************************************	
SURFACE CONDITION		UND AS WEL	DED	☐ MACHINED	☐ SHOT BLA	STED	CLEAN	BARE METAL	
SURFACE TEMPERA			0°F то 10°С/50	°F	□10°C/50°F	то 52°C/125°F	□ > 52°C	/125°F	
RESULTS-	(METRIC	: 🔾 IMPERIAL)							
ITEM	COM	MENTS	ACCEPT REJECT			~~~			
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accepted	by inceneen	ing/O.C.				VITUIU			
Scope of Services The agreement of Acuren	Group Inc. to perform serv	vices extends only to those services provide	ded for in writing. Una	ler no circumstances shall suc	ch services extend beyo	and the performance of the	e requested services.	It is expressly understood	
that all descriptions, com	ments and expressions of o	pinion reflect the opinions or observation	ns of Acuren Group Inc. owner/operator and th	. basea on information una as e owner/operator retains com	ssumptions supplied by aplete responsibility for	r the engineering, manufo			
data or other information	provided by Acuren Group	o Inc. In no event shall Acuren Group Inc	c. s tiability in respect o	of the services rejerred to here	in exceed the amount p	outer for such services.			
In performing the services implied, is made or intend	s provided, Acuren Group I ded by Acuren Group Inc.	Inc. uses the degree, care and skill ordina	rily exercised under si	milar circumstances by others	s perjorming such serv	ices in the same or simil	ir locality. No oliter		
SIGNATURES									
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